

2007-09-07 1:31:26 PM

Process Sheet

Ref: : CU-DAR001 Dart Helicopters Services
 Number: : 34512
 Date Number: : 10278
 Number: : N/A
 Issue: : 9/10/2007 S.O. No.: N/A
 Rev. : NC
 Issue: : N/A Type: : MACHINED PARTS
 Job Run: : 33694
 By: :
 Ed & Approved By: :
 Client: : Est Rev/Pick: A 04.02.18 New issue KJ/DS

Drawing Name: : BRACKET ASSEMBLY
 Part Number: : D3121141
 Drawing Number: : D3121 REV D
 Project Number: : N/A
 Drawing Revision: : D
 Material: : N/A
 Due Date: : 9/30/2007
 Qty: : 24
 Um: : Each

Final Product

Number:



q. #:	Machine Or Operation:	Description:
1.0	M174B1000X02000	17-4 SS Bar

Comment: Qty.: 0.5775 f(s)/Unit Total: 13.8600 f(s)

Material: 17-4 SS Bar per AMS 5604/5643

(M17-4-B1.000x02.000)

Identify for D3121-111

Batch: M174B1000X02000 M174B1000X02000

SL offload

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW

Cut blanks: (1.000" x 2.000") 6.600" long

SL offload

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine D3121-111 as per Folio FA361 and Dwg D3121 Identify as D3121-111

PTD

2-Deburr

SL/JF 07/11/03

3-Scribe batch number

22

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SL/JF 07/11/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

This one is
missing from the
W/O. It was in
Eng. and Qty is 23
with this one.

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/10/13	3	1 part is scrap because part when out of the fixture.	J.F. 07/10/13	Scrap & replace part	J.F. 07/10/13	J.F. 07/10/13	J.F. 07/10/13	J.F. 07/10/13
07/10/13	3	1 part thickness is .002" under minimum tolerance. A.C: Part moved in the vice when facing.	LE 07.11.13 QS1042	Acceptable. Groove depth measured to be 0.029" and calculation redone per stress report. Drawing revised to change groove tolerance.	J.F. 07/10/13	LE 07.11.13 QS1042	LE 07.11.13 QS1042	LE 07.11.13

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 34512

Part Number: D3121141

Number:



q. #: Machine Or Operation:

Description :

5.0 QC8



Comment: SECOND CHECK

JUL 07 11.02

6.0 D312121

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3121-21

Bolt B34522 X1 07/11/15

B34522 X1 07/11/15 SL/JF 07/11/15

7.0 D3121241

Bearing Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3121-241 Bearing Ass B34523

B34523 X1 07/11/15

07/11/15 SL/JF 07/11/15

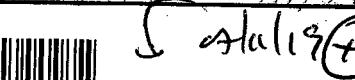
8.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3121-141 as per Dwg D3121.

ml 07/11/15 (X1)
SL/JF 07/11/15

Comment: INSPECT WORK TO CURRENT STEP

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 233

AS +1

07/11/05

07/11/15 (22)

(22)

11.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/11/05

07/11/10 (1)

Iteration:



DART AEROSPACE LTD

Work Order:

34512

Description: Bracket

Part Number:

D3121-111

Inspection Dwg: D3121

Rev: D

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST



First Article



Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.392	+0.002/-0.000	0.393"	✓			
0.75	+/-0.030	0.753"	✓			
0.375	+/-0.010	0.375"	✓			
2.14	+/-0.030	2.142"	✓			
0.950	+/-0.010	0.955"	✓			
0.600	+/-0.010	0.600"	✓			
1.96	+/-0.030	1.968"	✓			
0.280	+/-0.010	0.284"	✓			
3.330	+/-0.010	3.335"	✓			
3.630	+/-0.010	3.634"	✓			
R0.25	+/-0.030	R.250"	✓			
R0.375	+/-0.010	R.375"	✓			
Ø0.201	+0.005/-0.000	Ø.201"	✓			
0.100	+/-0.010	0.100"	✓			
6.18	+/-0.030	6.170"	✓			
5.89	+/-0.030	5.895"	✓			
0.080	+/-0.010	0.083"	✓			
0.300	+/-0.010	0.300"	✓			
30°	+/-0.1°	30°	✓			
R0.25	+/-0.030	R.25"	✓			
0.130	+/-0.010	0.125"	✓			
0.381	+/-0.010	0.373"	✓			
0.201	+/-0.010	0.202"	✓			
0.400	+/-0.010	0.398"	✓			
0.580	+/-0.010	0.575"	✓			
100°	+/-0.1°	100°	✓			
0.31	+/-0.010	0.32"	✓			

Measured by:

JF

Audited by:

SP

Prototype Approval:

N/A

Date:

07/10/11

Date:

07/10/11

Date:

N/A

Rev

Date

Change

P/O D3121-141

Revised by

Approved

A 04.01.12 New Issue

KJ/RF

B 04.05.05 Dimensions changed/re-arranged per Dwg revision

KJ/JLM

C 06.06.14 Dwg Rev. updated

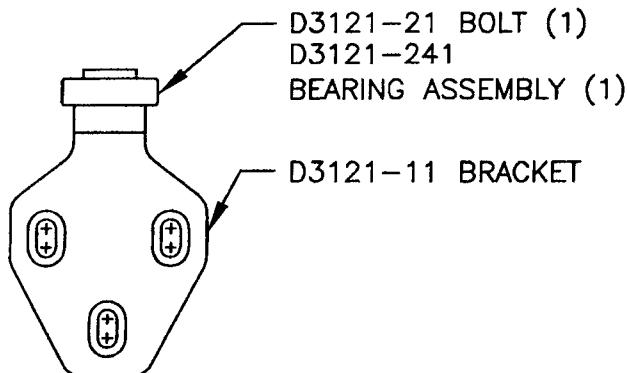
KJ/JLM

DART

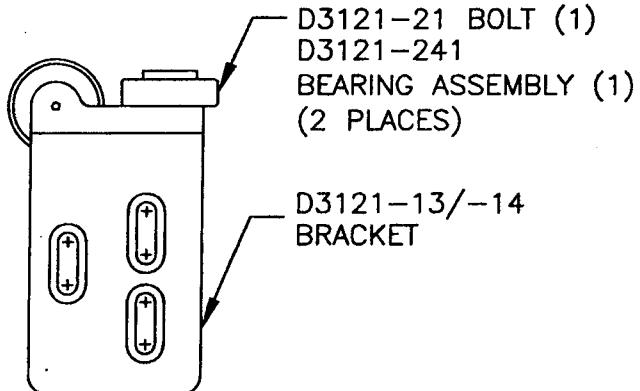
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED	APPROVED	DRAWING NO.	REV. D SHEET 1 OF 10	
DATE		TITLE	SCALE	
06.05.17		BRACKET ASSEMBLY	1:2	
		A 02.04.15	NEW ISSUE	
		B 03.01.16	ADD RIDGES; ADD MAT'L PROP; FIX P/N ADD -141/-143/-144/-145/-146	
		C 04.02.17	ADD CLEARANCE; USE -241 BEARING	
		D 06.05.17	D3121-25 CAP WAS 1.024, NOW 1.000	

RELEASED

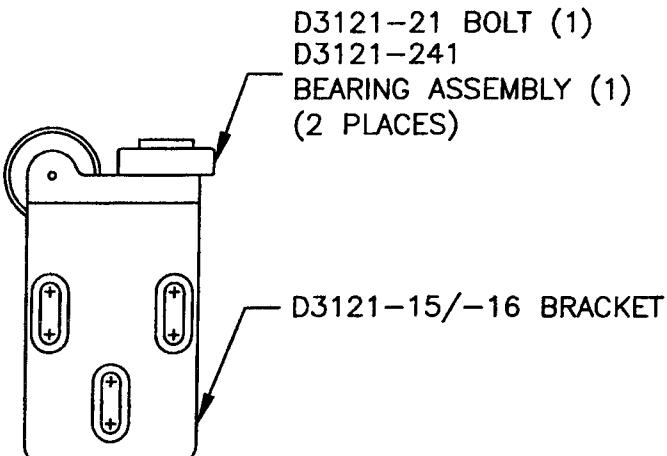
06.06.02



D3121-041 BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-33)



D3121-043 (SHOWN) / D3121-044 (OPPOSITE)
BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-37/-38)



D3121-045 (SHOWN) / D3121-046 (OPPOSITE)
BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-35/-36)

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